

Work Order ID 59850

Monday, June 14, 2010 2:32:17 PM



Page 1

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 6/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-6-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2572	Rev E								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

M.A 10/06/15

9 0

HAAS CNC vertical machine #1

Program Batch No. 59850

Double check by: *SM*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

M.A 10/06/15
10.6.17

9 0

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

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Page 2

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Start Date: 6/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

H.A 10/06/15

Memo

0.00

ml 10.6.17

9

0

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

ml 10/06/21

Memo

0.00

9

0

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

ml

10

06

21 (9)

Work Order ID 59850

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Page 3

Item ID: D2572

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd In 205

Stop



Start Date: 6/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M114841</i> Memo START TIME: <i>8:40</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>3200</i> <input type="checkbox"/> FINISH TIME: <i>9:10</i>	0.00 0.00				<i>9</i>		<i>BL 10.6-22</i>	
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>10.6.23</i>	<i>QCS</i>
170 Packaging Packaging	Identify as per dwg & Stock Location <i>433</i> Memo	0.00 0.00						<i>10/6/23</i>	<i>QCS</i>

Work Order ID 59850

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Page 4

Item ID: D2572

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd In 205

Stop



Start Date: 6/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23

W 10-06-23

Picklist Print

Monday, June 14, 2010 2:32:22 PM

Page 1

Work Order ID: 59850

Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205



Start Date: 6/14/2010

Required Date: 7/5/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I002.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005 		Manufactured	No			100	Each	82.0000	1	12			

Saddle Billet

Location

Loc Qty

Loc Code

MAT46

82

46411

44

58676

38

9 + 2.0 B.A 10/06/15

DART AEROSPACE LTD	Work Order:	39850
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.441	0.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.501	.500	.500	.500		
G	0.257	0.262		0.260	0.260	.260	.260		
H	0.375	0.380		0.376	0.376	.376	.376		
I	0.490	0.510		0.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.126	0.126	.126	.126		
Q	0.115	0.135		0.135	0.135	.135	.135		
R	0.240	0.260		0.250	0.250	.250	.250		
S	0.115	0.135		0.126	.130	.130	.130		
T	0.178	0.198		0.188	0.188	.188	.188		
U	2.940	2.980		2.959	2.959	2.960	2.960		
V	0.230	0.250		0.234	.236	.236	.236		
W	0.115	0.135		0.132	.130	.130	.130		
X	0.307	0.312		0.310	0.310	.310	.310		
Y	0.760	0.765		0.764	0.764	.764	.764		
Z	0.352	0.372		0.363	.363	.363	.363		
AA	0.470	0.530		0.500	0.500	.500	.500		
AB	0.615	0.635		0.615	0.625	.625	.625		
AC	0.053	0.073		0.063	0.063	.063	.063		
AD	0.240	0.260		0.248	.248	.248	.248		
AE	1.375	1.395		1.3883	1.3877	1.387	1.387		
AF	0.115	0.135		0.135	0.135	.135	.135		
AG	0.240	0.280		0.250	.250	.250	.250		
AH	0.240	0.260		0.248	.248	.248	.248		
AI	2.000	2.020		2.004	2.004	2.004	2.004		
AJ	0.023	0.043		0.033	0.033	.033	.033		
Accept/Reject									

Measured by:	M.A. <i>MA</i>
Date:	10/06/16 10.6.17

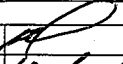
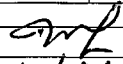
Audited by:	<i>MA</i>
Date:	10/06/21



Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>MA</i>

DART AEROSPACE LTD	Work Order: 59750
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	#6	#7	#8	By	Date
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.002	8.002		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.126	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.959	2.959	2.959		
V	0.230	0.250		.234	.234	.234	.234		
W	0.115	0.135		.132	.132	.132	.132		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.363	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.615	.615	.615	.615		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.248	.248		
AE	1.375	1.395		1.388	1.388	1.388	1.388		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.248	.248	.248	.248		
AI	2.000	2.020		2.008	2.008	2.008	2.008		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 	Audited by: 
Date: 10.6.18	Date: 10/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM 	

DART AEROSPACE LTD		Work Order: 59730
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	10	11	12		
A	0.438	0.443		.440					
B	1.745	1.755		1.750					
C	3.495	3.505		3.500					
D	1.745	1.755		1.750					
E	7.990	8.010		8.001					
F	0.490	0.510		.501					
G	0.257	0.262		.258					
H	0.375	0.380		.377					
I	0.490	0.510		.501					
J	1.174	1.184		1.177					
K	0.558	0.578		.567					
L	1.174	1.184		1.177					
M	1.490	1.500		1.492					
N	2.495	2.505		2.500					
O	3.869	3.879		3.872					
P	0.115	0.135		.126					
Q	0.115	0.135		.135					
R	0.240	0.260		.250					
S	0.115	0.135		.129					
T	0.178	0.198		.188					
U	2.940	2.980		2.957					
V	0.230	0.250		.238					
W	0.115	0.135		.134					
X	0.307	0.312		.308					
Y	0.760	0.765		.762					
Z	0.352	0.372		.362					
AA	0.470	0.530		.500					
AB	0.615	0.635		.626					
AC	0.053	0.073		.063					
AD	0.240	0.260		.248					
AE	1.375	1.395		1.387					
AF	0.115	0.135		.135					
AG	0.240	0.280		.246					
AH	0.240	0.260		.246					
AI	2.000	2.020		2.004					
AJ	0.023	0.043		.033					
Accept/Reject									

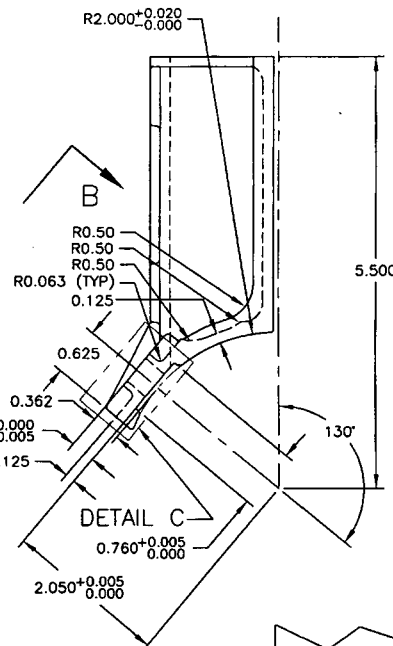
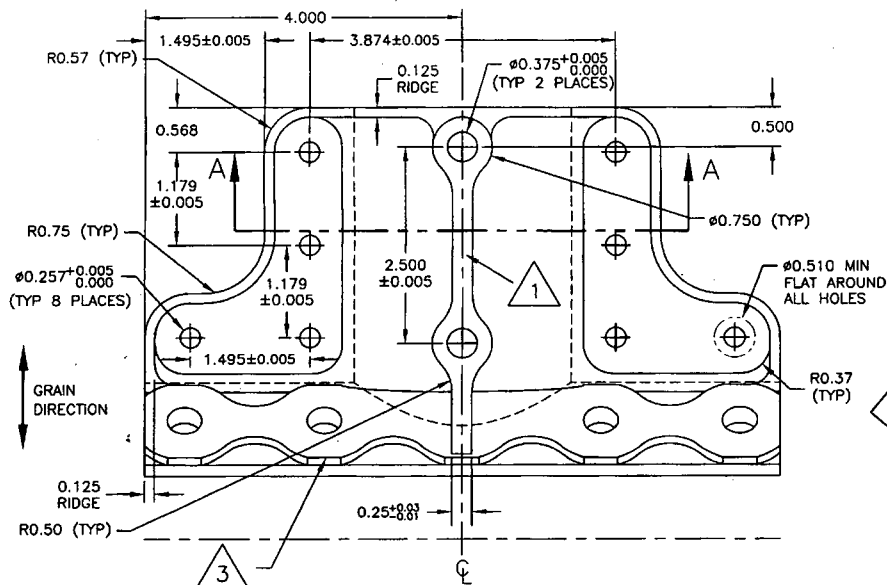
Measured by:	H.A
Date:	10/06/18

Audited by:	Amf
Date:	10/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

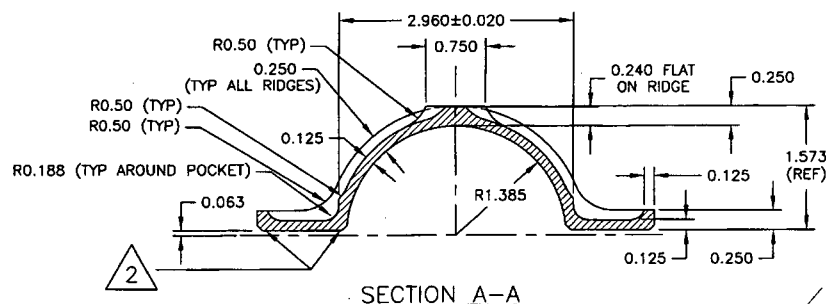
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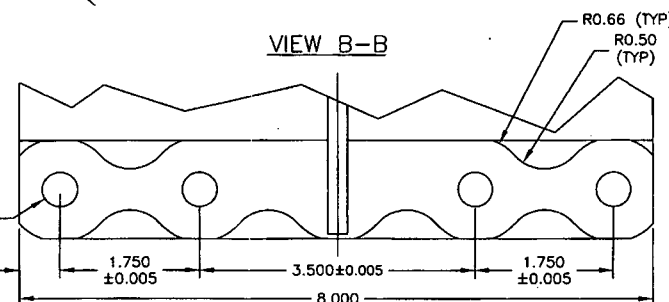
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

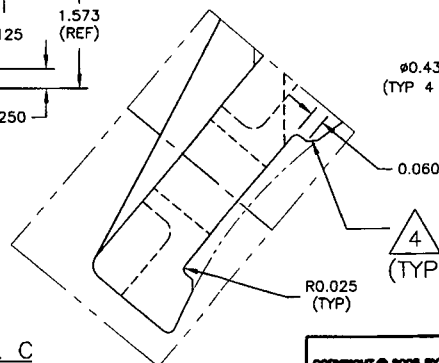
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



SECTION A-A



VIEW B-B



DETAIL C
SCALE 2:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 09280

BS10-6-74

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE INNER FWD SADDLE
		DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D2572
		REV. E SHEET 1 OF 1
		SCALE 2:3

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